

Work Order ID 72433

Monday, July 25, 2011 2:37:48 PM

Page 1

Item ID: D4017-041 Accept Setup Start Stop
 Revision ID:
 Item Name: Short Basket Base Assembly (350)
 Start Date: 7/25/2011 Start Qty: 1.00 Cust Item ID:
 Required Date: 8/8/2011 Req'd Qty: 1.00 Customer:
 Reference:
 Run Start Stop

Approvals: Process Plan: Date: 7-25 Tooling: Date:
 QC: Date: SPC (Y/N): Date:
 Date: Date: Date: Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4017	C

100 Weld per dwg A/R S.S. rod Batch: 1114649 0.00
 Large Fab

Large Fab Memo 0.00
 1- assemble ribs , weld as per dwg D4017 using DT9610B
 inspect before welding mesh
 2- tack weld mesh on basket as per dwg D4017 and trim mesh to fit if necessary
 and trim to clear fasteners holes on the ends
 3- weld hinge (3) and Mounting brackets as per dwg D4017
 take lid to locate hinge and bracket

110 QC9- Inspect visual per QS1004- Fusion Welds 0.00

QC Memo 0.00
 Quality Control

PMB 11/07/28

BE 11/08/03
 11-08-03 1 φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Accept



Setup Start



Revision ID:

Stop



Item Name: Short Basket Base Assembly (350)

Start Date: 7/25/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/8/2011 Req'd Qty: 1.00



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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 uloglof

125

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

1 6 uloglof

W/O:		WORK ORDER CHANGES					
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Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel Memo 1118439 Plug holes and mask only interior of hinge (3) prior to powder coat 1ST COAT: START TIME: 1:45 PM OVEN TEMPERATURE: 400° FINISH TIME: 2:15 PM ***** 2nd coat if necessary ***** 2ND COAT: START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____	0.00 0.00							<u>1</u> <u>0</u> <u>11/08/06</u>
140 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							<u>9511/08/09</u> <u>0</u>

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



Assemble as per dwg

0.00

HandFinish

Memo

0.00

Hand Finishing

EP 11/08/09 @

160



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

Smolor

+0

170



Identify as per dwg & Stock Location: GA

0.00

Packaging

Memo

0.00

Packaging

W/O
72431

EP 11/08/09 @

W/O:		WORK ORDER CHANGES					
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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

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Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

OK 11/08/09
MF
11-08-09

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Parent Item Name: Short Basket Base Assembly (350)




Start Date: 7/25/2011

Required Date: 8/8/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 09.11.30 verified by:EC IPP Rev:B as per dwg RevA DD 10.03.06 verified by:EC IPP Rev:C as per dwg RevB DD 10.04.16 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18 verified by:EC IPP Rev:E 10.11.04 added pressure wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status																					
D4017-1  Rib		Manufactured	No			100	Each	6.0000	1	1		10/07/28																						
<table><tr><th>Location</th><th>Loc Qty</th><th>Loc Code</th></tr><tr><td>WA</td><td>3</td><td></td></tr><tr><td>59957</td><td>0</td><td></td></tr><tr><td>71993</td><td>3</td><td></td></tr><tr><td>WA006</td><td>3</td><td></td></tr><tr><td>68394</td><td>1</td><td></td></tr><tr><td>68481</td><td>2</td><td></td></tr></table>														Location	Loc Qty	Loc Code	WA	3		59957	0		71993	3		WA006	3		68394	1		68481	2	
Location	Loc Qty	Loc Code																																
WA	3																																	
59957	0																																	
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WA006	3																																	
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68481	2																																	
D4018-1  Rib		Manufactured	No				Each	4.0000	1	1		10/07/28																						
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Location	Loc Qty	Loc Code																																
WA	4																																	
71992	1																																	
71996	3																																	
D4018-1 is the same as D4017-3																																		
D4017-5  Hinge Rib		Manufactured	No			100	Each	4.0000	1	1		10/07/28																						
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WA	4																																	
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B 67096

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Parent Item Name: Short Basket Base Assembly (350)

Start Date: 7/25/2011

Required Date: 8/8/2011

Start Qty: 1.00

Required Qty: 1.00

D4017-7

Manufactured No

100

Each

6.0000

1

1



Rib

Location

Loc Qty

Loc Code

WA

3

69730

1

71944

2

WA005

3

72008

3



Handwritten: PMB 11/07/28

D4017-9

Manufactured No

100

Each

12.0000

2

2



Rib

Location

Loc Qty

Loc Code

WA

6

70341

2

71742

4

WA006

6

72007

6



Handwritten: PMB 19/07/28

D3916-041

Manufactured No

100

Each

4.0000

2

2



Rib Assembly

Location

Loc Qty

Loc Code

WA

4

69161

2

71282

2

71994



Handwritten: PMB 19/07/28

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Start Date: 7/25/2011

Required Date: 8/8/2011

Start Qty: 1.00

Required Qty: 1.00

D3916-5

Manufactured No

100

Each

16.0000

1

1



Light Rib

Location

Loc Qty

Loc Code

WA

16

59088

3

69076

4

71938

9

D4034-041

Manufactured No

100

Each

6.0000

1

1



Aft Upper Rib Assembly

Location

Loc Qty

Loc Code

WA

5

71483

2

71972

3

WA006

1

69157

1

D4034-043

Manufactured No

100

Each

3.0000

1

1



Fwd Upper Rib Assembly

Location

Loc Qty

Loc Code

WA

2

71955

2

WA006

1

70241

1

7.
PAB 18/07/28

PAB 18/07/28

PAB 18/07/28

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Work Order ID: 72433

Parent Item: D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 7/25/2011

Required Date: 8/8/2011

Start Qty: 1.00

Required Qty: 1.00

D2581

Manufactured No

100 Each

63.0000 2 2



Mounting Bracket



AA
PMB 11/08/03

Location

Loc Qty

Loc Code

WA

63

69258

28

69739

2

70766

33

2

D3913-15

Manufactured No

100 Each

7.0000 1 1



Wide Handle Plate



AA
PMB 11/07/29

Location

Loc Qty

Loc Code

WA

6

69158

2

69647

4

WA005

1

69012

1

1

D4016-1

Manufactured No

100 Each

13.0000 3 3



Hinge Half, Base



AA
PMB 11/08/03

Location

Loc Qty

Loc Code

WA

13

66418

0

68426

3

70342

10

3

D4020-3

Manufactured No

100 Each

0.0000 1 1



Mesh (350 Basket Short, Base)



AA
PMB 11/08/02

B 72435

1

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Work Order ID: 72433

Parent Item: D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 7/25/2011

Required Date: 8/8/2011

Start Qty: 1.00

Required Qty: 1.00

D4020-11
End Mesh, Basket

Manufactured No

100 Each

6.0000

2 2

Handwritten: P.M.B. 11/08/03

Location

Loc Qty

Loc Code

WA

6

2

Handwritten: 72223

69648

2

71725

4

D4021-1
Handle Plate

Manufactured No

100 Each

33.0000

3 3

Handwritten: P.M.B. 11/07/29

Location

Loc Qty

Loc Code

WA

33

69518

6

69777

27

3

D2931
Bumper

Manufactured No

150 Each

614.0000

2 2

Handwritten: E.P. 11/08/09

Location

Loc Qty

Loc Code

ST504

614

46064

614

2

D4021-5
Blanking Plate

Manufactured No

150 Each

10.0000

2 2

Handwritten: E.P. 11/08/09

Location

Loc Qty

Loc Code

GA

8

70349

8

WA005

2

67008

2

2

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Page 5

Dart Aerospace Ltd

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Start Date: 7/25/2011

Required Date: 8/8/2011

Start Qty: 1.00

Required Qty: 1.00

AN3-10A Purchased No 150 Each 127.0000 6 6
Bolt

Location	Loc Qty	Loc Code
ST351	127	
117313	11	
117795	116	

AN960JD8 NAS1149DN832J Purchased No 150 Each 0.0000 2 2
Washer

MS20600-AD4W3 Purchased No 150 Each 845.0000 2 2
Cherry Rivets

Location	Loc Qty	Loc Code
ST321	712	
111636	112	
117505	452	
117601	148	
WA018	133	
107939	133	

MS21042L3 Purchased No 150 Each 1,389.000 6 6
Nut

Location	Loc Qty	Loc Code
ST300	1389	
117441	629	
117601	400	
117885	360	

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Start Date: 7/25/2011

Required Date: 8/8/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P

Purchased

No

150

Each

276.0000

12

12



WASHER



EP 11/08/07

Location

Loc Qty

Loc Code

ST275

276

117735

87

118354

186

17317

3

12

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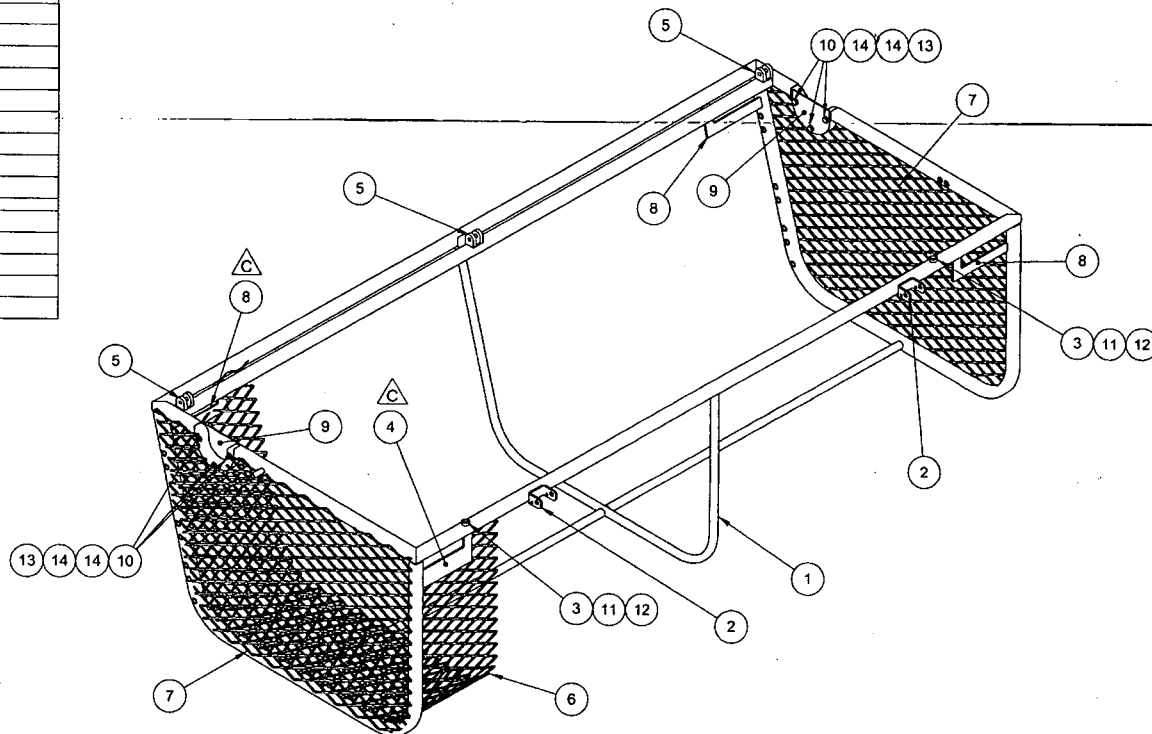
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ITEM	QTY -041	P/N	DESCRIPTION
	X	D4017-041	SHORT BASKET BASE ASSY (350)
1	1	D4017-101	TUBULAR ASSY (350 SHORT BASKET)
2	2	D2581	MOUNTING BRACKET
3	2	D2931	BUMPER
4	1	D3913-15	WIDE HANDLE PLATE
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-3	MESH (350 BASKET SHORT BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20600AD4W3	RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 724133
11-07-25



D4017-041 SHORT BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

ECN 10-546
RELEASED
10.06.17

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 28.8 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

C	ITEM #4 NOW INSTALLED OUTBOARD (C4-1, C5-1, B5-2 AND D8-2). REASON: ELIMINATE INTERFERENCE PREVENTING INSTALLATION OF RECEIVER ASSEMBLIES.	MB	10.07.23
B	QTY 1 D4021-1 REPLACED WITH QTY 1 D3913-15; AN3-10A BOLT WAS AN3C10A; NAS1149F0332P WASHER WAS NAS1149C0332R; SECTION F-F UPDATED (D8-2); ITEMS RENUMBERED; DETAIL D UPDATED (A4-3)	JPH	10.03.25
A	NEW ISSUE	AJS	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	ALJ		
DRAWN			
CHECKED			
MFG. APPR.	J.F.S.		
APPROVED			
DE APPR.			
DATE	10.07.23		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4017 TITLE SHORT BASKET BASE ASSY (350) SCALE NTS <small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			

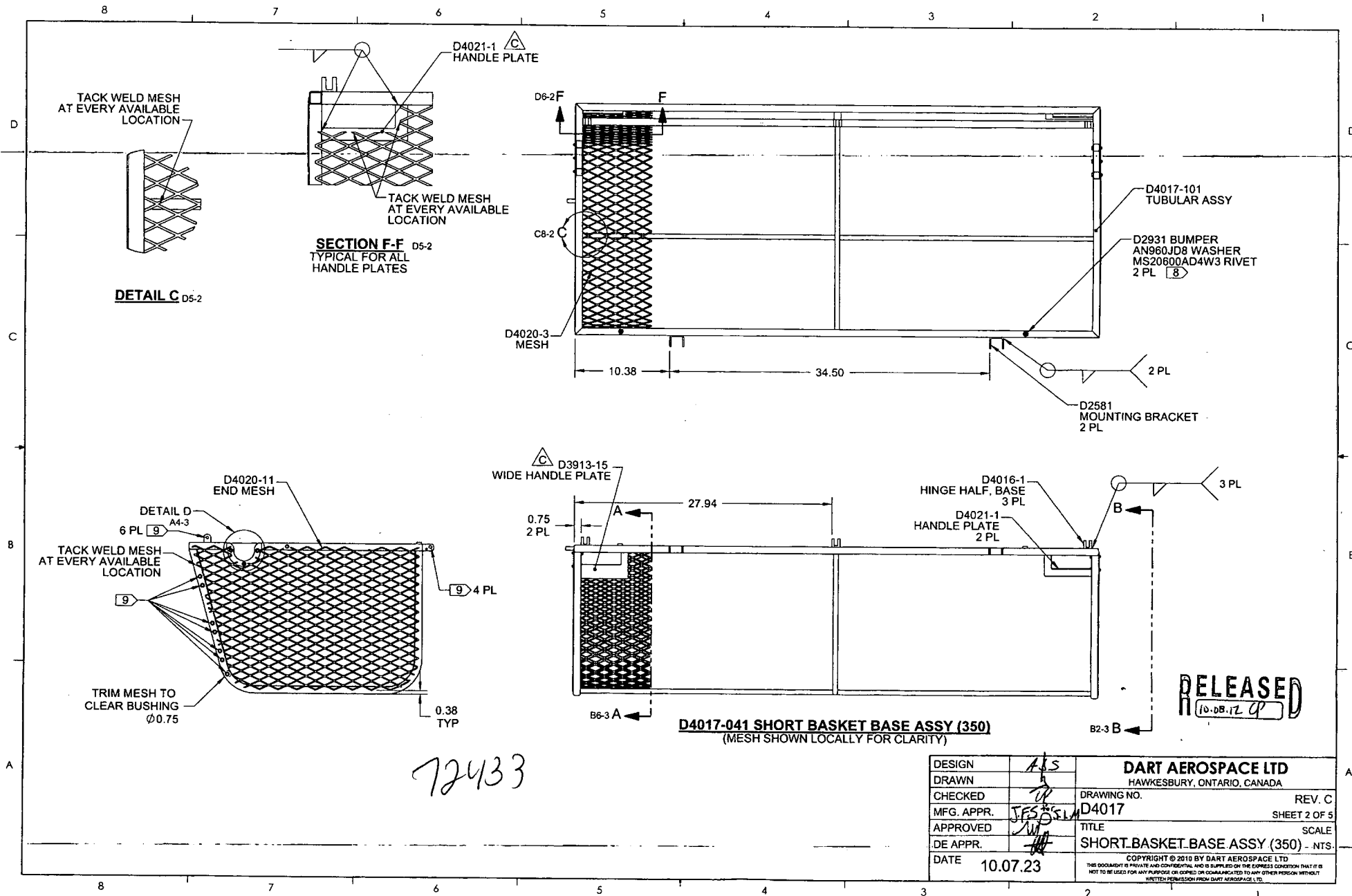
Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	JP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	JFS	D4017	SHEET 2 OF 5
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	SHORT.BASKET.BASE ASSY (350) - NTS	
DATE	10.07.23	COPYRIGHT © 2016 BY DART AEROSPACE LTD	
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

C

B

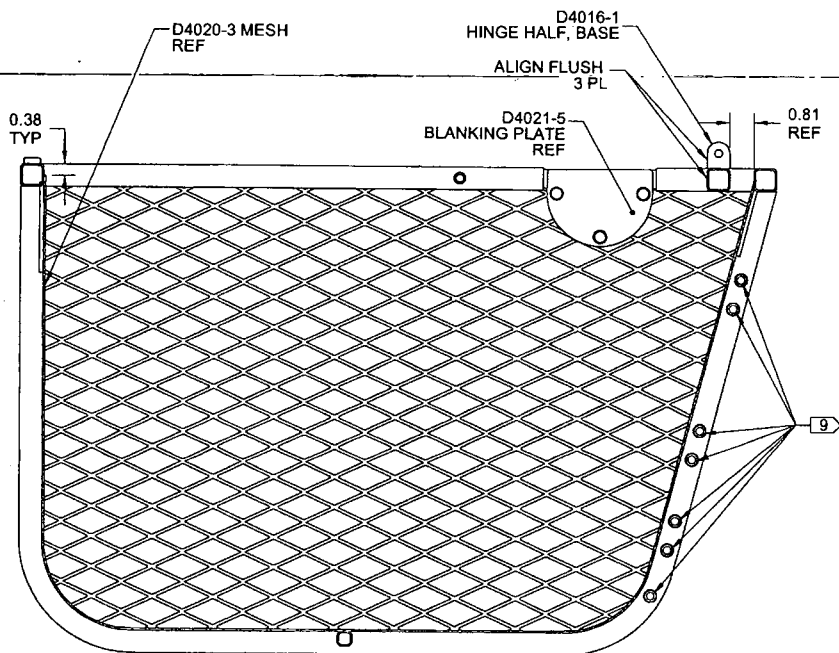
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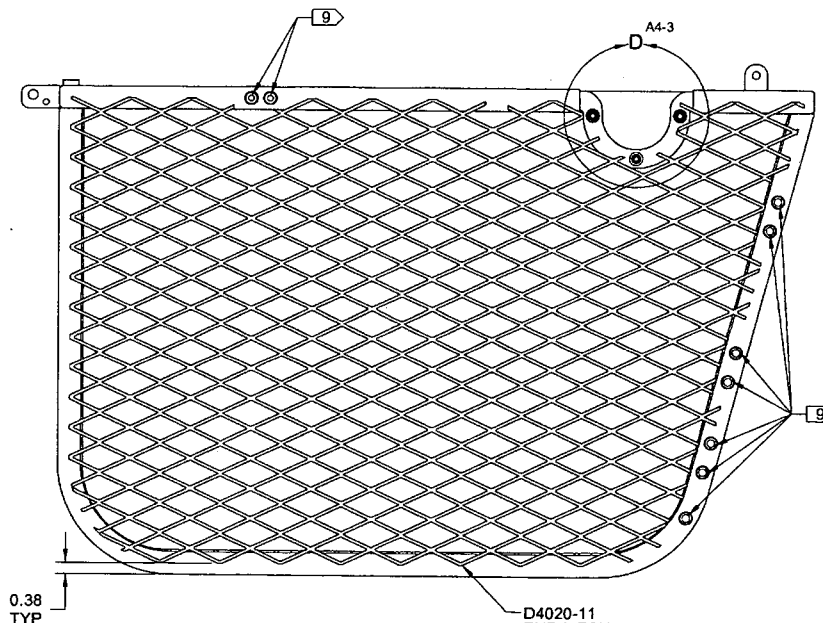
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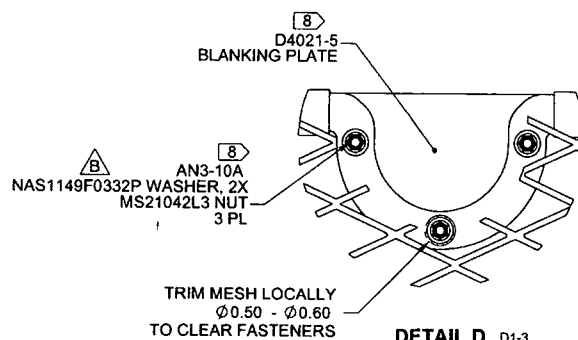
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SECTION A-A A5-2



SECTION B-B A2-2



DETAIL D D1-3 B8-2

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RELEASED
10.08.12

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	JP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JFS	DRAWING NO. D4017	REV. C
MFG. APPR.	JFS		SHEET 3 OF 5
APPROVED	JM	TITLE	SCALE
DE APPR.	JM	SHORT-BASKET-BASE ASSY (350)	-NTS
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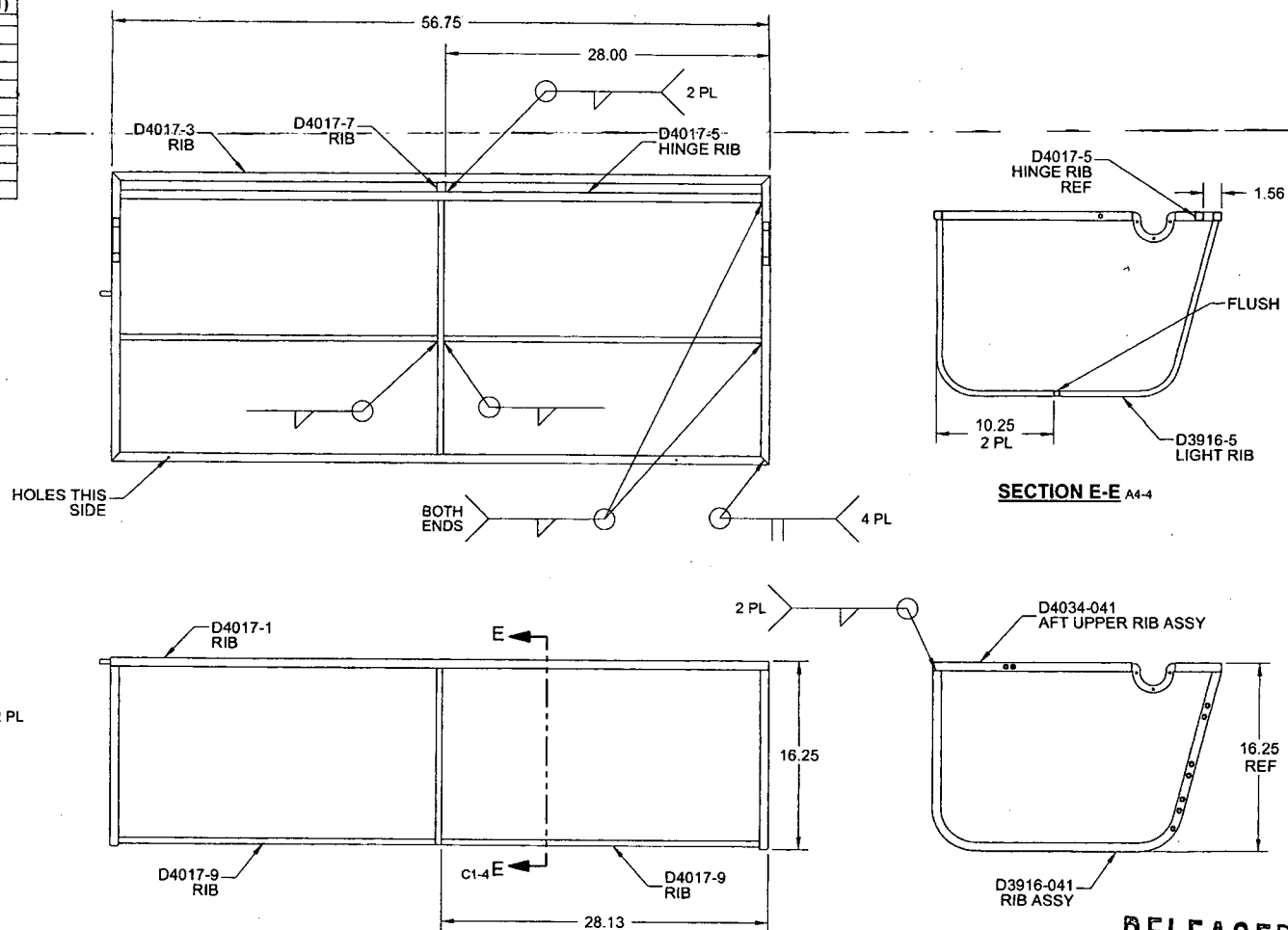
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -101	P/N	DESCRIPTION
	X	D4017-101	TUBULAR ASSY (350 SHORT BASKET)
1	1	D4017-1	RIB
2	1	D4017-3	RIB
3	1	D4017-5	HINGE RIB
4	1	D4017-7	RIB
5	2	D4017-9	RIB
6	2	D3916-041	RIB ASSY
7	1	D3916-5	LIGHT RIB
8	1	D4034-041	AFT UPPER RIB ASSY
9	1	D4034-043	FWD UPPER RIB ASSY



- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 15.26 lbs
 - 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4017-101
 - 9) WELD PER DART QSI 004

8 D4017-101 TUBULAR ASSY (350 SHORT BASKET)

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DESIGN	AKS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	DRAWING NO. D4017	REV. C SHEET 4 OF 5
DRAWN	AKS			
CHECKED	AKS			
MFG. APPR.	AKS			
APPROVED	AKS			
DE APPR.	AKS	TITLE SHORT BASKET-BASE ASSY (350)	SCALE NTS	
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10.09.17

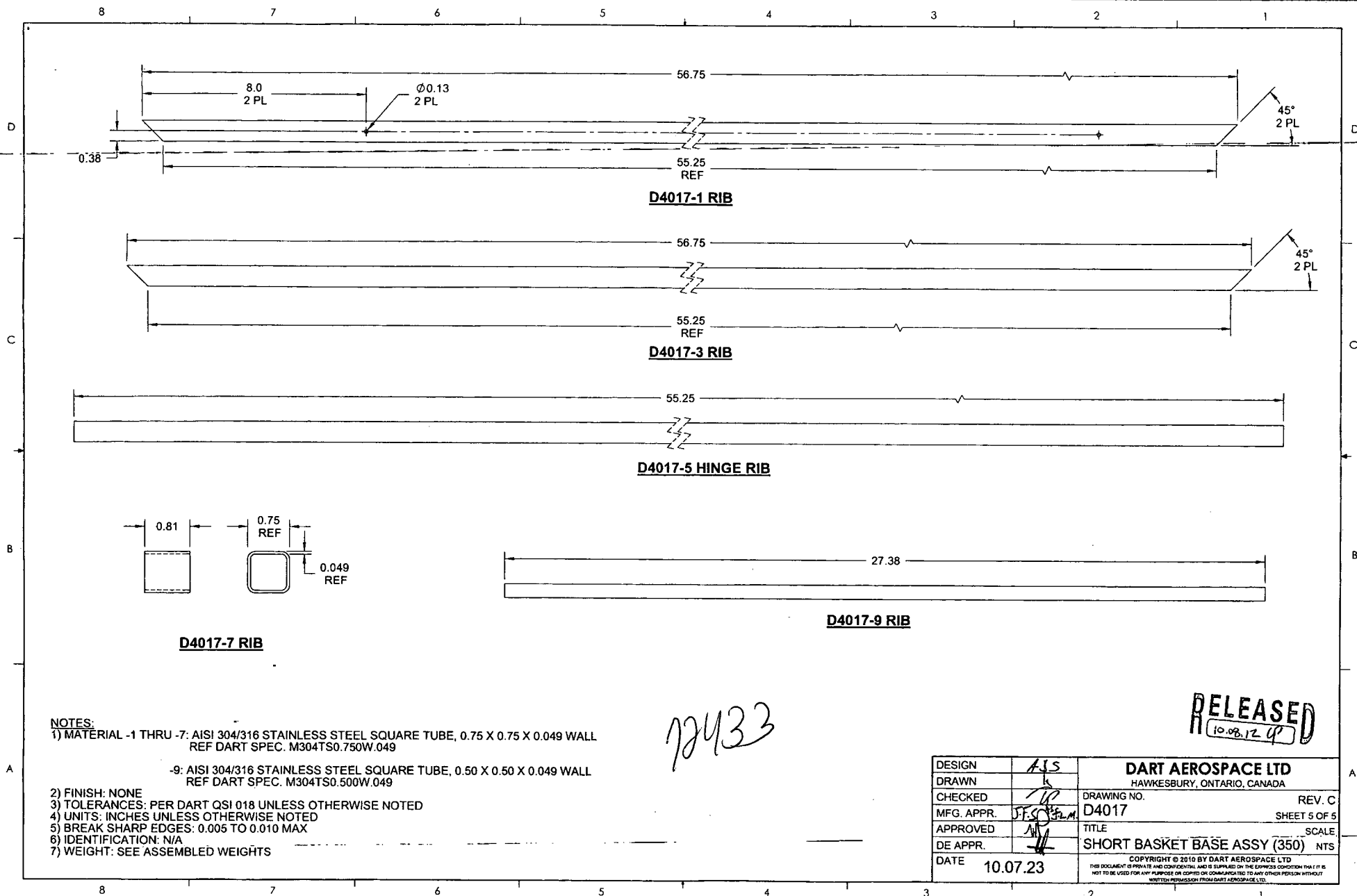
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